PC-GF

Technical Data Sheet

infinite™

Pellets developed and manufactured for use in Large Format Additive Manufacturing (LFAM) applications offer several key advantages over many commonly used materials, including:

- **Low to zero warpage** for dimensional stability
- **Printable without a heated chamber,** enabling broader equipment compatibility
- **125°C heat deflection temperature (HDT)** for better thermal performance
- **Custom color options** to meet branding or aesthetic requirements
- **Suitable for various applications** including construction, furniture, automotive, and more

Properties (PRINTED PARTS)

Property	Typical Value	Units	Method
Flexural Strength (XY)	15000	PSI	ASTM D790
Flexural Strength (XZ)	15400	PSI	ASTM 790
Flexural Strength (ZX)	4900	PSI	ASTM 790
Tensile Strength (XY))	12500	PSI	ASTM D638
Tensile Strength (XZ)	13200	PSI	ASTM D638
Tensile Strength (ZX)	2400	PSI	ASTM D638
Post - Pull (ZX)	3600	PSI	**ASTM 638
Coefficient of Thermal Expansion	1.56E-05	in/in°C	ASTM 6341
Melt Flow Index (300°C @ 2.16kg)	21.09	g/10 min	ASTM 1238
Heat Deflection Temperature	126.8	°C	ASTM 648
Specific Gravity	1.43	N/A	ASTM 792
Pellet Size	2.5 x 2.5	mm	Target

**Based on ASTM D638 Procedural Guidelines (Non-Standard Specimen Geometry)

PRINTING CONDITIONS

Setting	Typical Value	Units	Notes
Zone 1	240-250	°C	Inlet
Zone 2	250-260	°C	
Zone 3	255-285	°C	
Zone 4	265-295	°C	Nozzle
Chamber	0	°C	Not Required
Bed	0	°C	Not Required
Adhesion Promotor	Infinite ™ LFAM Adhesive		
Flow Rate	125	%	
Extruder Torque	25-35	%	
Nozzle Size	10	mm	As Tested
Bead Width	15	mm	As Tested
Layer Height	5	mm	As Tested
Optimal Layer Time	2-3	Minutes	
Drying	4 hrs @ 250°F	°F	<.05% M.C